

Date: Wednesday, 06/09/2006 11:05:14 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT ARM
<b>Job Number</b> : 28421	
<b>Estimate Number</b> : 12515	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D35271
<b>This Issue</b> : 06/09/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3527 UNDER REVIEW <i>06.09.05</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A	<b>Drawing Revision</b> : UNDER REVIEW
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <i>EL</i>	<b>Due Date</b> : 13/09/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est Rev:A New Issue 06-08-28 EC	

Additional Product

PRELIMINARY ISSUE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	<del>M0061T6T0375W035</del>	6061-T6 Tube .375 x.035W
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M304 TR0375W035



**Comment:** Qty.: 0.3885 f(s)/Unit Total: 1.5540 f(s)

M304 Tube

6061 T6 Tube .375 x.035W

Batch: N 18993

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut tube 4.375" long

2-Press ends and drill as per dwg D3527

3-Bend ends as per dwg D3527

4-Deburr

*SB 06/09/06*

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*N/A**P10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DE Date: 26/08/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:15 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ARM

Job Number: 28421

Part Number: D35271

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 09 13 ②

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NOT REQUIRED FOR TESTING  
CB 07.07.20



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51447

06/09/14 ②

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

06/09/14 ②

Job Completion



U 06/09/14

ENG APPROVAL

PART INSPECTED AFTER INSTALLATION  
PART OK FOR TESTING ONLY

CB 07.07.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

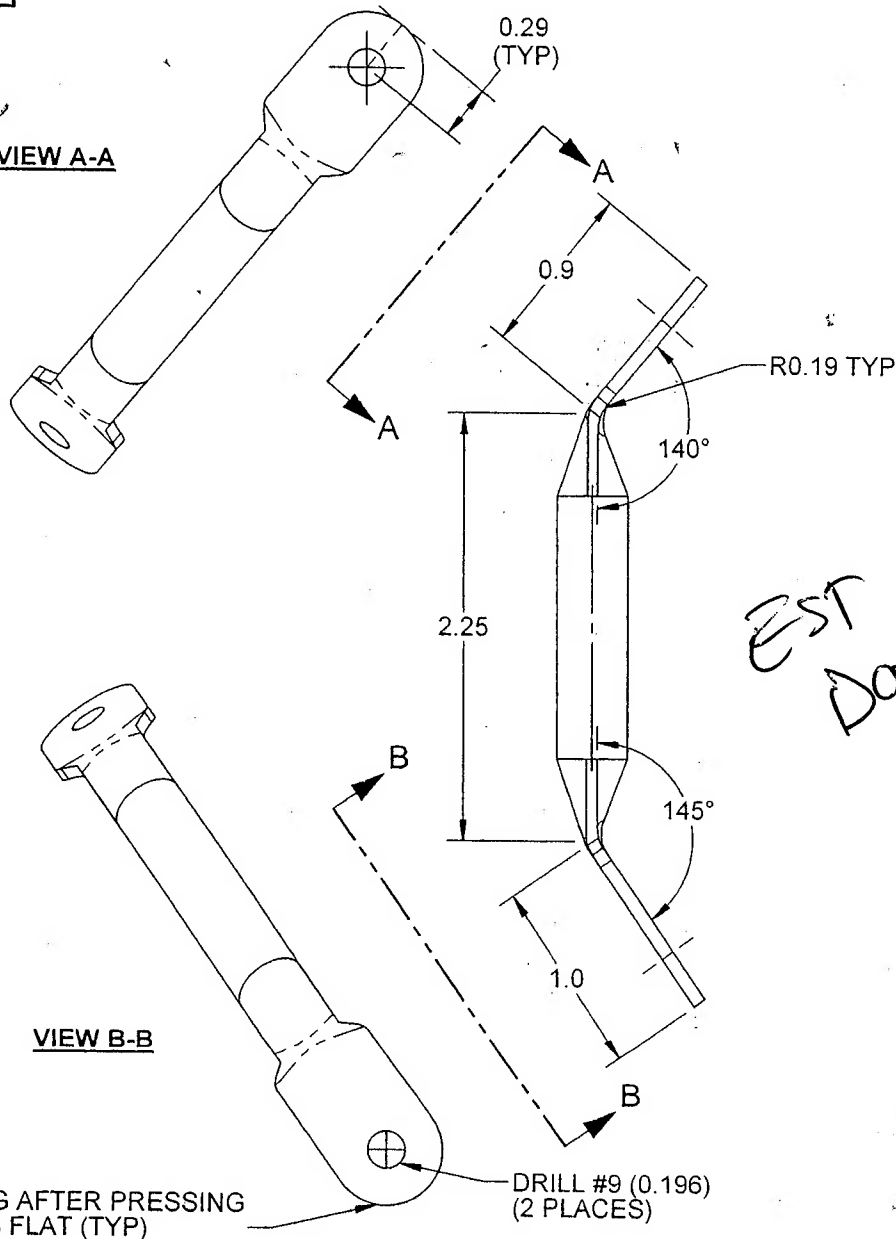
# PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3527	REV. A
DATE 06.05.02		TITLE SUPPORT ARM	SHEET 1 OF 1
A	06.05.02	NEW ISSUE	SCALE 1:1

UNDER REVIEW

OG-08.22 CB  
prototype

VIEW A-A



ROUND LUG AFTER PRESSING  
TUBE ENDS FLAT (TYP)

DRILL #9 (0.196)  
(2 PLACES)

## D3527-1 SUPPORT ARM

### NOTES:

- 1) MATERIAL: ~~6061-T6 ALUMINUM TUBE (QQ-A-200/8 OR QQ-A-225/8)~~ 304 Stainless Steel (REF DART SPEC. M6061T6T0.375W.035)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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